

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007047**Date Inspected:** 28-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

OBG Sub-Assembly Bay 12:

The QA Inspector randomly observed ZPMC welder Xu Guo Yin ID 059443, utilizing the Flux Cored Arc Welding (FCAW) Process in the 2G/2F (Horizontal Groove/Horizontal Fillet) Positions with ZPMC Weld Procedure Specification (WPS) WPS-345-FCAW-2G (2F)-Repair-1 to weld repairs in WJ 003, attaching a U-Rib to Deck Plate 7BW-DP196-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welders Xia Jun ID 068253 and Jiang Jin Yong ID 060361, utilizing the Shielded Metal Arc Welding (SMAW) Process in the 2G (Horizontal Groove) Position with ZPMC WPS WPS-345-SMAW-2G (2F) Repair-1 to weld repairs to WJ's 013 (B-WR2501) 015 (B-WR2538) respectively, attaching T=35 mm I-Ribs to the base plate on Deck Plate 1AW-DP575-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed ZPMC welder Xiang Huan Feng ID 059416, utilizing the FCAW Process in the 2G/2F (Horizontal Groove/Horizontal Fillet) Positions with ZPMC WPS WPS-345-FCAW-2G

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

(2F)-Repair-1 to weld repairs in WJ 008, attaching a U-Rib to Deck Plate 7BW-DP250-001. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. Weld parameters appeared to comply with contract requirements.

The QA Inspector randomly observed 1 ZPMC helper utilizing an angle grinder to blend the U-Rib welds after repairs on Deck Plate 7BW-DP250-001.

The QA Inspector performed a 100% Final Visual "In Process" Inspection on all of the welds on Deck Plate 1AE-DP595-001. The QA Inspector marked up 7 areas for minor re-work. ZPMC QC directed ZPMC welding personnel to perform the minor re-work. The QA Inspector re-inspected the 7 areas. There appeared to be no indications and the QA Inspector accepted the welds and signed the "In Process" Yellow Tag Number 004027 on 1AE-DP595-001.

Plate Storage Yard:

The QA Inspector verified material traceability of steel plate from Batch 186 to be cut for a Check Sampling, identified the areas to be cut with Caltrans Lot Numbers B216-26-09 through B216-31-09 and the direction of rolling. The cut Check Samples will be prepared for shipment to the testing lab in Shanghai.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
